

# Work Order ID 51152

August 4, 2009 3:23:10 PM



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Item ID:	D3684-045	Accept		Setup	Start	
Revision ID:	C				Stop	
Item Name:	LEG ASSEMBLY					
Start Date:	08/24/2009	Start Qty:	1.00	Cust Item ID:		
Required Date:	08/28/2009	Req'd Qty:	5.00	Customer:		
Reference:						

Approvals:	Process Plan:	<i>mf</i>	Date:	<i>09-05-09</i>	Tooling:		Date:		Run	Start	
	QC:		Date:		SPC (Y/N):		Date:			Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
<b>Draw Nbr</b>	<b>Revision Nbr</b>								
D3684	Rev C								
100	Pick Kit	0.00							
	Packaging								
	Memo	0.00							
	Packaging								
110	Small Fab	0.00							
	Small Fab								
	Memo	0.00							
	Small Fab								
	1-Use anti-seize compound Tectly 502c Class 1, Mil-PRF-16173E or equivalent on thread and assemble as per dwg D3684 □2-Assemble D3693-1 & D3691-1 Using Sikaflex -241/-291 between mating surfaces as per Dwg D3684□***Ensure holes for AN3C Bolts are free of sealant								
120	QC5- Inspect part completeness to step on W/O	0.00							
	QC								
	Memo	0.00							
	Quality Control								

*SB 09/08/17* *(4)*

*4 2*

*SB 09/08/17*

*27 509/08/18* *(x4) 0*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

**Work Order ID 51152**

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Item ID: D3684-045

Accept



Setup Start



Revision ID: C

Stop



Item Name: LEG ASSEMBLY

Start Date: 08/24/2009 Start Qty: 5.00



Cust Item ID:

Required Date: 08/28/2009 Req'd Qty: 5.00



Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	Identify as per dwg & Stock Location: <u>139E</u>	0.00							
Packaging	Memo	0.00							
Packaging									
140	QC21- Final Inspection - Work Order Release	0.00							
QC	Memo	0.00							
Quality Control									

9/8/18 @ SP

09/08/21 AJ

MF 09-08-21

# Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

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Work Order ID: 51152

Parent Item: D3684-045RevC

Parent Item Name: LEG ASSEMBLY


Comments:

Start Date: 08/24/2009

Required Date: 08/28/2009

Start Qty: ~~5.00~~ 4

Required Qty: 5.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
AN3C12A  Bolts		Purchased	No			110	Each	635.0000	8 10.0000			

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST

635

106993

7

110155

2

110552

4

110584

72

111916

50

112314

500

D3688-5RevB

Manufactured No

110

Each

11.0000

4  
5.0000

MF 09-08-15

STUD

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST

11

46054

11

D3689-1RevB

Manufactured No

110

Each

19.0000

4  
5.0000

4x MF 09-08-15

SLEEVE

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST

19

46051

19

50358x4 MF 09-08-15

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

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August 4, 2009 3:23:10 PM

Work Order ID: 51152



Parent Item: D3684-045RevC



Parent Item Name: LEG ASSEMBLY

Start Date: 08/24/2009

Required Date: 08/28/2009

Comments:

Start Qty: 5.00

Required Qty: 5.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D3691-1RevU/R		Manufactured	No			110	Each	17.0000	<del>5.0000</del>			
STUD												

Warehouse                      Loc Qty                      Loc Code

Location

Main Warehouse

ST

17

46052

17

B50721 MF 09-08-15

D3692-1RevB

Manufactured No

110

Each

106.0000

~~20.0000~~



SPACER

Warehouse                      Loc Qty                      Loc Code

Location

Main Warehouse

ST

106

44827

68

45672

38

50325

16 SB 09/08/12

4

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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Work Order ID: 51152



Parent Item: D3684-045RevC



Parent Item Name: LEG ASSEMBLY

Start Date: 08/24/2009

Required Date: 08/28/2009

Comments:

Start Qty: 5.00

Required Qty: 5.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D3693-1RevU/R		Manufactured	No			110	Each	33.0000	4 5.0000			



Rod End Bearing

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST

5

45723

5

Main Warehouse

ST127

28

50734

28

MS21043-3

Purchased

No

110

Each

5,590.000

8  
10.0000



Nut

Warehouse Loc Qty Loc Code

Location

OFFSHORE

FG

80

103691

80

Main Warehouse

ST

5510

111819

210

112243

300

112314

5000

MF 09-08-15

MF 09-08-15

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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Work Order ID: 51152



Parent Item: D3684-045RevC



Parent Item Name: LEG ASSEMBLY

Start Date: 08/24/2009

Required Date: 08/28/2009

Comments:

Start Qty: 5.00

Required Qty: 5.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
NAS509L12C		Purchased	No			110	Each	135.0000	4/5.0000			
Nuts												

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

135

106993

5

110844

30

112314

100

MF 09-08-15

PTO

August 4, 2009 3:23:10 PM

Shop Packet Print

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Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	
09/08/18	110	add NAS509-12C M 112453	SB	09/08/18	4			

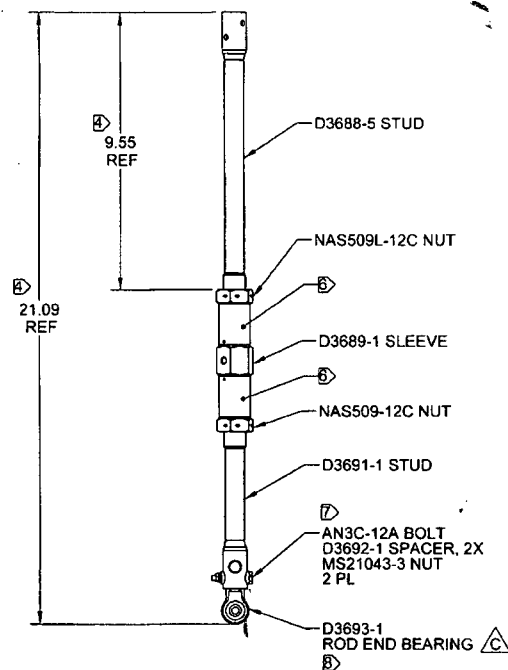
Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

ITEM	QTY -045	PART NUMBER	DESCRIPTION
1	X	D3684-045	INBOARD LEG ASSEMBLY
2	1	D3688-5	STUD
3	1	D3689-1	SLEEVE
4	1	D3691-1	STUD
5	4	D3692-1	SPACER
6	1	D3693-1	ROD END BEARING
7	2	AN3C-12A	BOLT
8	2	MS21043-3	NUT
9	1	NAS509L-12C	NUT
10	1	NAS509-12C	NUT







**D3684-045 INBOARD LEG ASSEMBLY**

**RELEASED**  
09/01/2015

**NOTES:**

- 1) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 2) UNITS: INCHES UNLESS OTHERWISE NOTED
- 3) IDENTIFICATION: IDENTIFY WITH DART ASSEMBLY P/N D3684-045 USING FINE POINT PERMANENT INK MARKER
- 4) DIMENSION SHOWN IS WHEN D3688-5 & D3691-1 STUDS ARE FULLY THREADED INTO D3689-1 SLEEVE
- 5) WEIGHT: 3.1 lbs
- 6) USE TECTYL 502C CLASS I, MIL-PRF-16173E GRADE 2 OR EQUIVALENT ANTI-SEIZE COMPOUND ON THREAD
- 7) TORQUE FASTENERS TO 20-25 in-lbs
- 8) ASSEMBLE D3693-1 WITH D3691-1 USING SIKAFLEX-241/-291 OR PROSEAL 890 OR MIL-S-8802 CLASS 'B' SEALANT BETWEEN MATING SURFACES. ENSURE HOLES FOR AN3C BOLTS ARE CLEAR OF SEALANT

DESIGN	RF	<b>DART AEROSPACE LTD</b>	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. C
MFG. APPR.		D3684	SHEET 3 OF 5
APPROVED		TITLE	SCALE
DE APPR.		TRIPOD MOUNT ASSY	NTS
DATE	08.12.15	COPYRIGHT © 2008 BY DART AEROSPACE LTD	
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